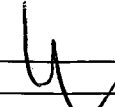
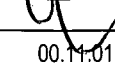


Date: Tuesday, 23/12/2008 12:53:30 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, RH, 206
Job Number : 44283	
Estimate Number : 10523	
P.O. Number :	Part Number : D26652
This Issue : 23/12/2008 S.O. No. :	Drawing Number : D2665 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 43808	Material :
Written By : 	Due Date : 09/01/2009 Qty: 6 Um: Each
Checked & Approved By : 	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101003	Saddle Billet, 7075
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length

Ink 09/01/02

Batch: B34873

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

- 1- Program batch number
- 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet
- 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet
- 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet
- 5- Deburr

Ink 09/01/02

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------

**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Ink 09/01/05

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Ink 09/01/02

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

J.L 09/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 12:53:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 44283

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

921

09-07-01

(X)6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:10

OVEN TEMPERATURE:

320°

FINISH TIME:

9:40

FL 08/01/07

(6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-01-07

(X)6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST436

SS 09/01/08 (X)6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 09/01/08

(6)

Job Completion



MF 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44283
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.111	.111	.111	.111		
B	0.100	0.140		.117	.123	.122	.121		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		.680	.680	.680	.680		
E	0.240	0.260		.253	.253	.253	.253		
F	1.313	1.343		1.327	1.326	1.326	1.326		
G	0.210	0.230		.223	.223	.223	.223		
H	0.100	0.180		.137	.146	.146	.146		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.236	.236	.236	.236		
L	0.100	0.120		.110	.112	.112	.112		
M	0.990	1.010		1.002	1.002	1.001	1.001		
N	0.510	0.515		.511	.511	.511	.511		
O	5.990	6.010		6.006	6.006	6.000	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.360	1.361		
V	0.787	0.807		.794	.796	.795	.796		
W	0.540	0.560		.547	.547	.548	.549		
X	1.674	1.684		1.680	1.679	1.677	1.677		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.924	.921	.921	.917		
AA	0.490	0.510		.502	.500	.500	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	ML	Audited by:	SL
Date:	09/01/02	Date:	09/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	44283
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

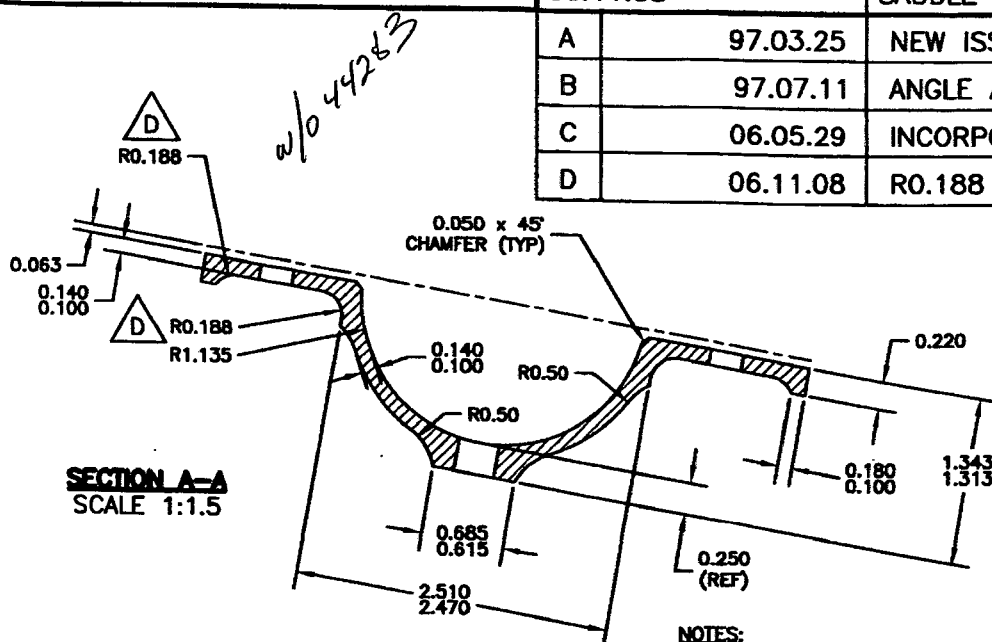
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.711	.111				
B	0.100	0.140		.120	.120				
C	1.125	1.145		1.135	1.135				
D	0.615	0.685		.680	.680				
E	0.240	0.260		.253	.253				
F	1.313	1.343		1.326	1.327				
G	0.210	0.230		.223	.223				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.575	1.575				
K	0.235	0.240		.236	.236				
L	0.100	0.120		.112	.112				
M	0.990	1.010		1.001	1.001				
N	0.510	0.515		.571	.571				
O	5.990	6.010		6.000	5.999				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.315	.315				
S	0.315	0.322		.321	.321				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.364	1.364				
V	0.787	0.807		.795	.795				
W	0.540	0.560		.547	.546				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.259	.259				
Z	0.912	0.932		.919	.919				
AA	0.490	0.510		.500	.500				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	ML	Audited by:	SL
Date:	09/01/02	Date:	09/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



DESIGN A		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH		APPROVED A		DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08				TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.29		INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08		R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

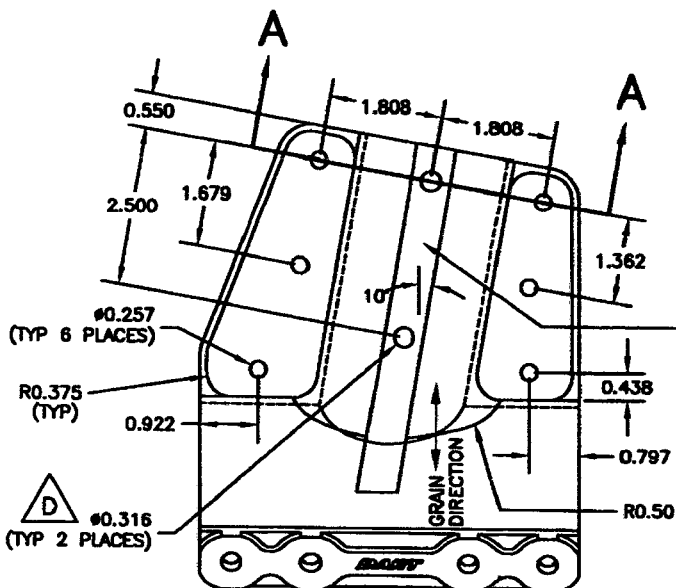


RELEASED

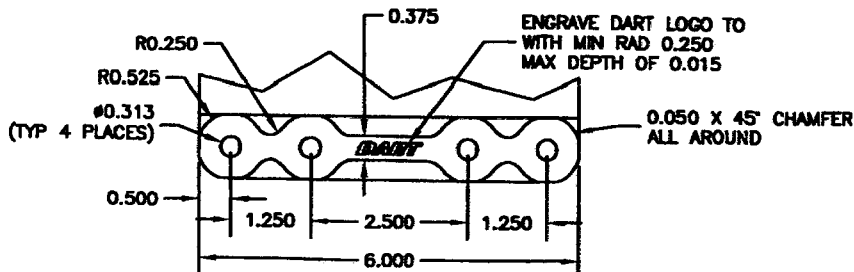
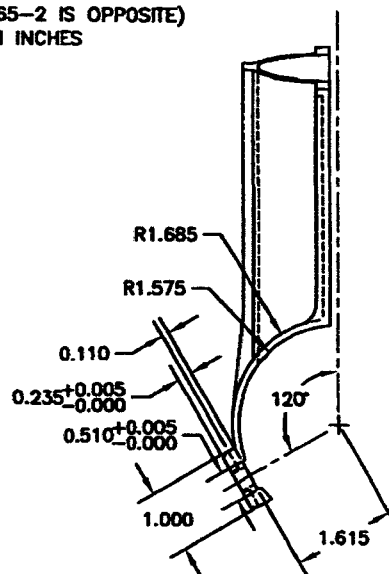
07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADUS
OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

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